

Work Order ID 103031

103031

Page 1

June-12-13 9:25:36 AM

Item ID: D4095-049 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad Assembly
 Start Date: 6/17/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/17/13 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4095 | B | | | | | | | | |

100 FLOW WATER JET 0.00
 100 12 0 Jm13-06-23
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg (D4095-9)
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary
 304.063
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110 12 0 Jm13-06-23
 QC Memo 0.00
 Quality Control
 120 QC8- Inspect parts - second check 0.00
 120 12 13-06-24
 QC Memo 0.00
 Quality Control

DAS
09
2-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | | | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Page 2

June-12-13 9:25:36 AM

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 Revision ID: Stop *NS2*
 Item Name: Wearpad Assembly
 Start Date: 6/17/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/17/13 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| 130 *130* Brake NC Brake NC | Form as per dwg NC BRAKE Memo | 0.00 0.00 | | | | 12x | | | ES 3/06/28 |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | 12 | | | 13628 |
| 150 *150* Large Fab Large Fab | Weld per dwg A/R Hardcoat S.S. Batch: 11125337 Large Fab Memo | 0.00 0.00 | | | | 12 | | | 13-07-03 JBL |

DQA: _____ Date: _____



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Work Order update only ☐

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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
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| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
| | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

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Start Date: 6/17/13 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 6/17/13 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|------------------------------|--------------|---------------|---------------|------------------|----------------|
| 160 *160* QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | DAS 16 9-89 13/6/04 | | | | | |
| 170 *170* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | DAS 16 9-89 13/6/04 | | (10) | | | |
| 180 *180* HandFinish Hand Finishing | COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 125382 | 0.00 0.00 | | | | 10 | 0 | 0 | 18 13-7-6 |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
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FAULT CATEGORY

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June-12-13 9:25:36 AM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 *190* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 10 | | | |
| 200 *200* Packaging Packaging | Identify as per dwg & Stock Location: <i>SP 002</i> Memo | 0.00 0.00 | | | | | | | |
| 210 *210* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

WAS 21 13-7-8

10 6 1378.

13/7/8

MF 13-7-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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| Material | | | | | | | | | |
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| Offset/Setup | | | | | | | | | |
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| Training | | | | | | | | | |
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Picklist Print

June-12-13 9:25:36 AM

Page 1

Work Order ID: 103031

Parent Item: D4095-049

Parent Item Name: Wearpad Assembly

Start Date: 6/17/13

Required Date: 6/17/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|------------------------|---------------|----------------|--------|
| M304S16GA 304/316 Sheet .063 | | Purchased | No | | | | sf | 280.7102 | | 10.0 2.0 | | | JmB-23 |

Location

Loc Qty

Loc Code

MAT020

280.7101686

122245

0.1713688

123136

140.8

124428

23.61

124572

7.0181688

125599

109.110631

25599

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
|--|--|--|--|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
| Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

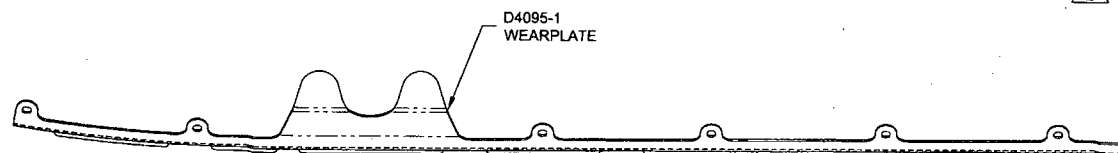
| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

FIRST ARTICLE INSPECTION CHECKLIST

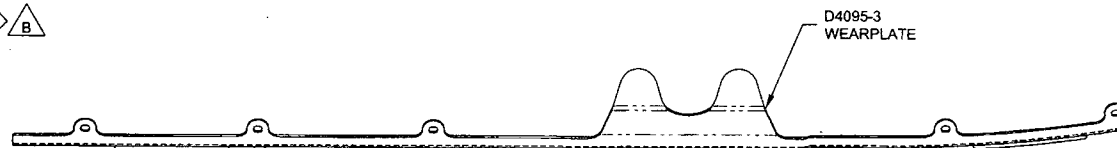
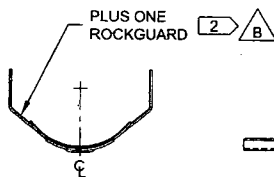
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------------|------------|--------------------|
| A | 11.11.08 | New Issue P/O D4095-049 | KJ | <i>[Signature]</i> |

| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | PART NUMBER | DESCRIPTION |
|------|----------|----------|----------|----------|----------|----------|-------------|--------------------------------|
| 1 | X | | | | | | D4095-041 | WEARPLATE ASSEMBLY |
| 2 | | X | | | | | D4095-043 | WEARPLATE ASSEMBLY |
| 3 | | | X | | | | D4095-045 | WEARPLATE ASSEMBLY |
| 4 | | | | X | | | D4095-047 | WEARPAD ASSEMBLY |
| 5 | | | | | X | | D4095-049 | WEARPAD ASSEMBLY |
| 6 | | | | | | X | D4095-051 | WEARPAD ASSEMBLY |
| 7 | 1 | | | | | | D4095-1 | WEARPLATE |
| 8 | | 1 | | | | | D4095-3 | WEARPLATE |
| 9 | | | 1 | | | | D4095-5 | WEARPLATE |
| 10 | | | | 1 | | | D4095-7 | WEARPAD |
| 11 | | | | | 1 | | D4095-9 | WEARPAD |
| 12 | | | | | | 1 | D4095-11 | WEARPAD |
| 13 | A/R | A/R | A/R | A/R | A/R | A/R | 4715 (4714) | PLUS ONE ROCKGUARD BLACK (TAN) |

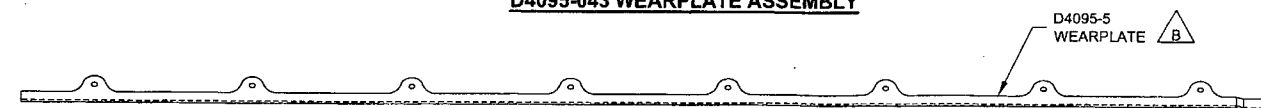
w/o 103031



D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY

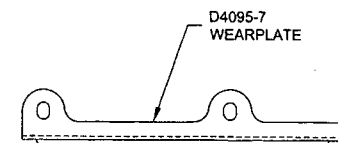
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

| | | | |
|------------|---|-----|----------|
| B | REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2 | XDF | 11.10.18 |
| A | NEW ISSUE | MB | 10.04.20 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | XDF | | |
| CHECKED | 10 | | |
| MFG. APPR. | 10 | | |
| APPROVED | 10 | | |
| DE APPR. | 10 | | |
| DATE | 11.10.18 | | |

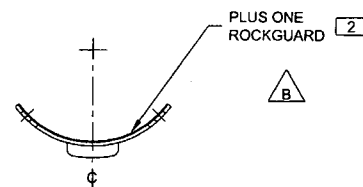
| | |
|--------------------------------|--------------|
| DART AEROSPACE USA, INC | |
| KENT, WA | |
| DRAWING NO. | REV. B |
| D4095 | SHEET 1 OF 8 |
| TITLE | SCALE |
| WEARPLATE | NTS |

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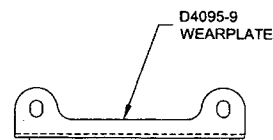


D4095-7
WEARPLATE

D4095-047 WEAR PAD ASSEMBLY

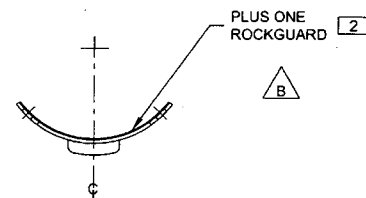


PLUS ONE
ROCKGUARD

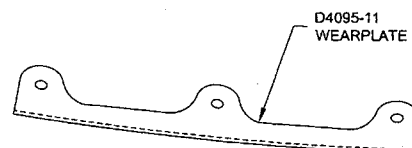


D4095-9
WEARPLATE

D4095-049 WEAR PAD ASSEMBLY

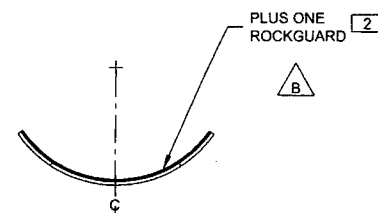


PLUS ONE
ROCKGUARD



D4095-11
WEARPLATE

D4095-051 WEARPAD ASSEMBLY

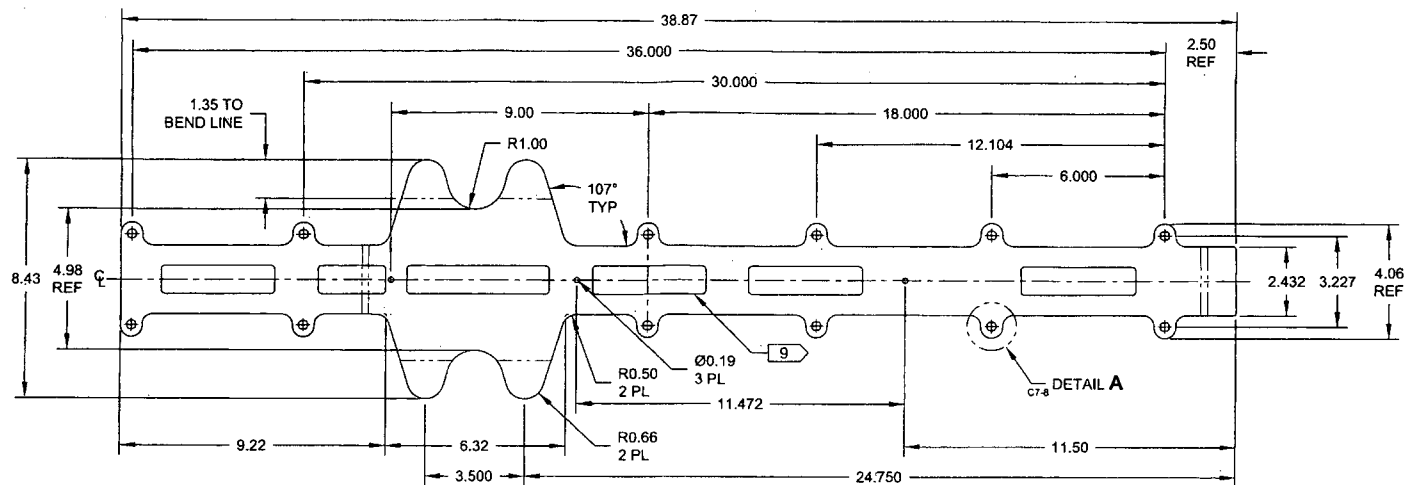


PLUS ONE
ROCKGUARD

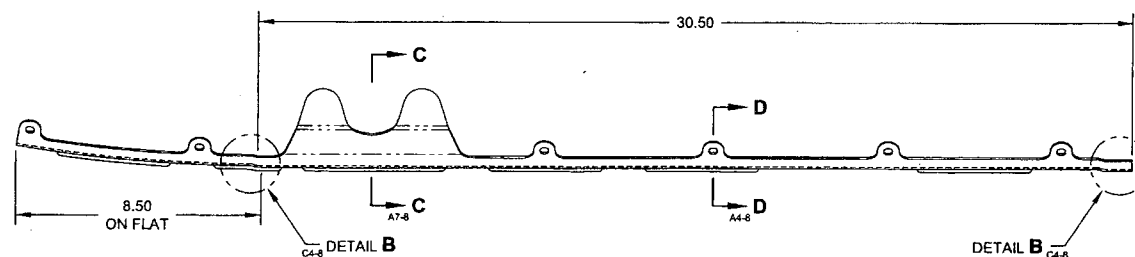


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2011-10-31
JWP

| DESIGN | | DART AEROSPACE USA, INC | |
|------------|----------|---|--------------|
| DRAWN | XDF | KENT, WA | |
| CHECKED | NO | DRAWING NO. | REV. B |
| MFG. APPR. | NO | D4095 | SHEET 2 OF 8 |
| APPROVED | NO | TITLE | SCALE |
| DE APPR. | NO | WEARPLATE | NTS |
| DATE | 11.10.18 | <small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |



D4095-1F FLAT PATTERN 1



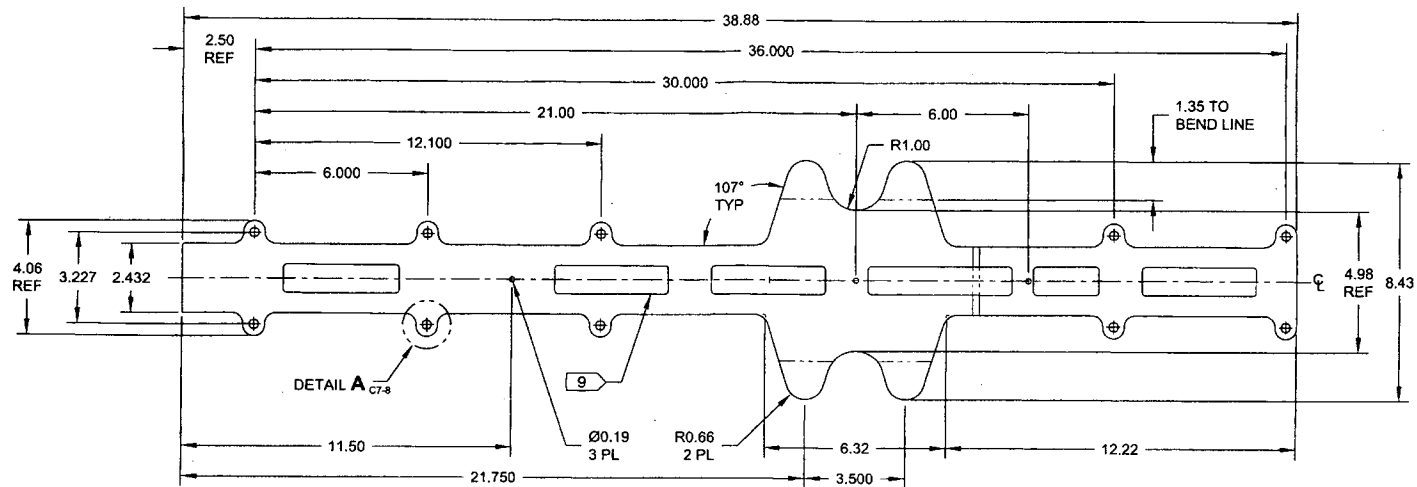
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/1F/3/3F/5/5F/7/7F/9/9F/11/11F NOTES:

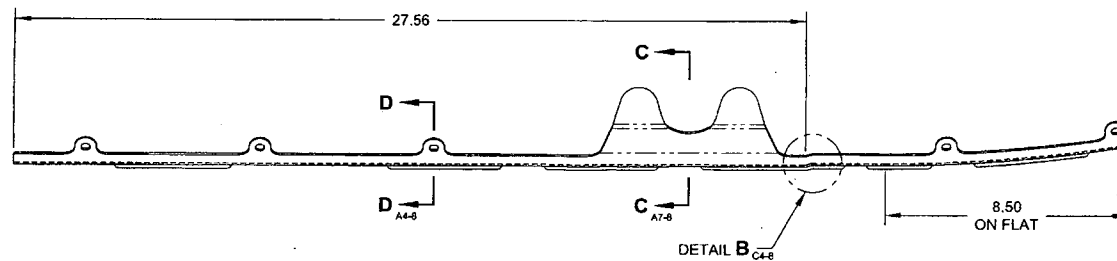
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

| | | | |
|---|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC | |
| DRAWN | XDF | KENT, WA | |
| CHECKED | AP | DRAWING NO. | REV. B |
| MFG. APPR. | AP | D4095 | SHEET 3 OF 8 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | WEARPLATE | NTS |
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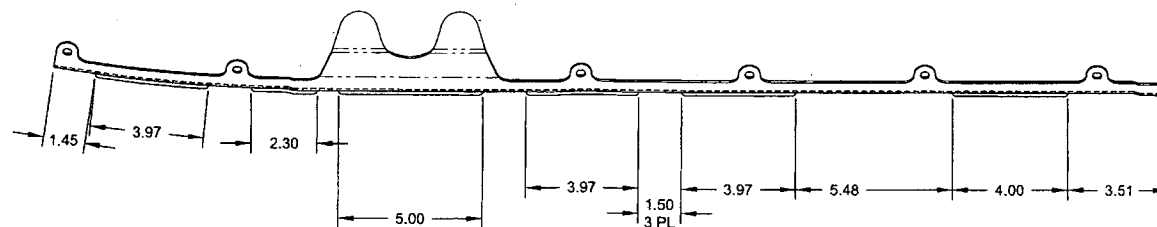
D4095-3F FLAT PATTERN 1



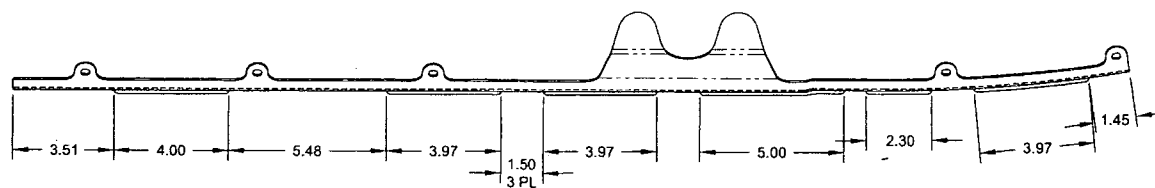
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

RELEASE
2011-10-31

| | | | |
|------------|----------|--|--------------|
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| DRAWN | XDF | KENT, WA | |
| CHECKED | 10 | DRAWING NO. | REV. B |
| MFG. APPR. | 10 | D4095 | SHEET 4 OF 8 |
| APPROVED | 10 | TITLE | SCALE |
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D4095-1 WELDING DETAIL

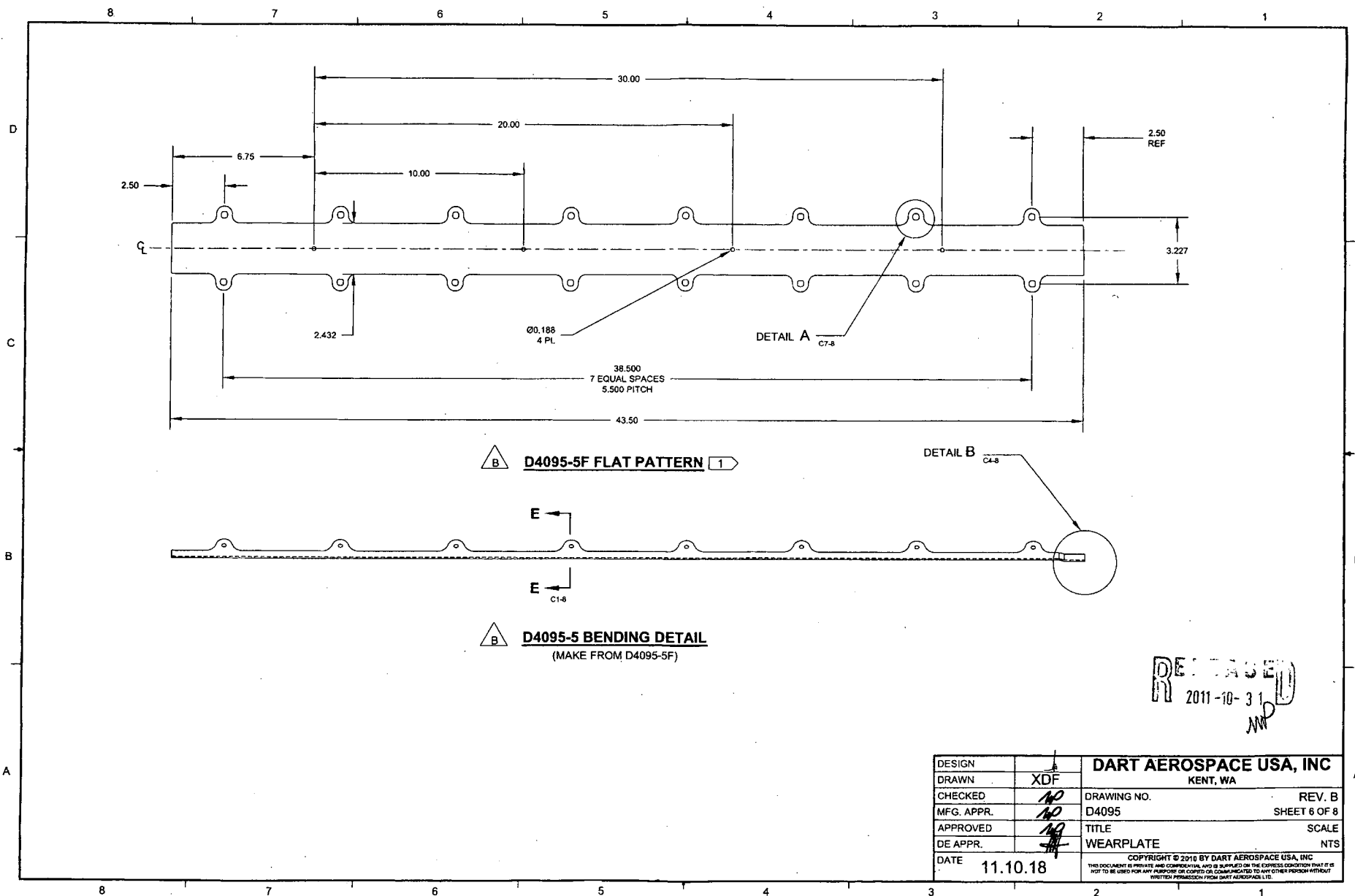


D4095-3 WELDING DETAIL



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2011-10-31
M

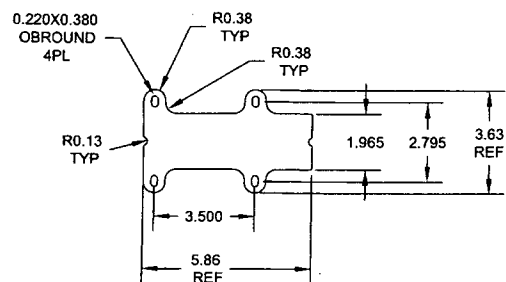
| DESIGN | | DART AEROSPACE USA, INC | |
|------------|----------|--|--------------|
| DRAWN | XDF | KENT, WA | |
| CHECKED | AP | DRAWING NO. | REV. B |
| MFG. APPR. | AP | D4095 | SHEET 5 OF 8 |
| APPROVED | AP | TITLE | SCALE |
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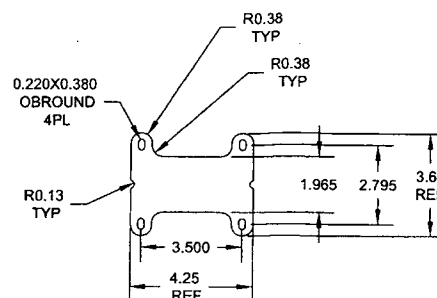
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|-------------------------|----------|--------------------|
| KENT, WA | | |
| DESIGN | | |
| DRAWN | XDF | |
| CHECKED | AP | DRAWING NO. REV. B |
| MFG. APPR. | AP | D4095 SHEET 6 OF 8 |
| APPROVED | AP | TITLE SCALE |
| DE APPR. | AP | WEARPLATE NTS |
| DATE | 11.10.18 | |

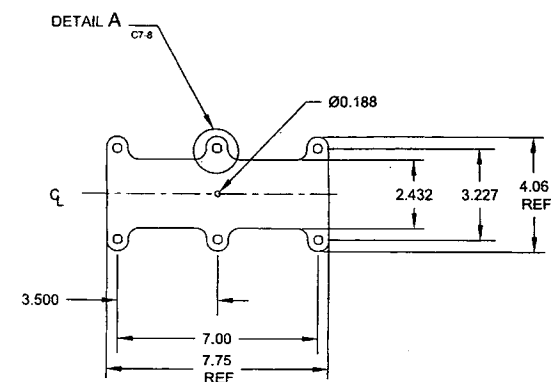
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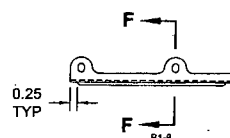
D4095-7F FLAT PATTERN 1



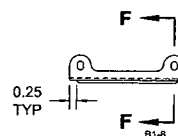
D4095-9F FLAT PATTERN 1



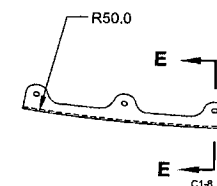
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



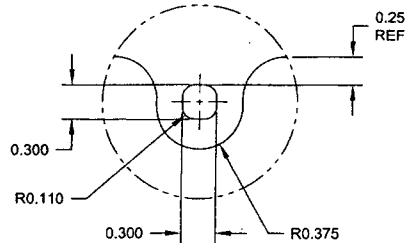
D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

| | | |
|------------|----------|---|
| DESIGN | | DART AEROSPACE USA, INC |
| DRAWN | XDF | KENT, WA |
| CHECKED | 10 | DRAWING NO. REV. B |
| MFG. APPR. | 10 | D4095 SHEET 7 OF 8 |
| APPROVED | 10 | TITLE SCALE |
| DE APPR. | 10 | WEARPLATE NTS |
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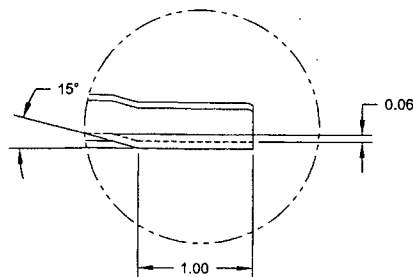
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DETAIL A: TAB DETAIL

SCALE 4X

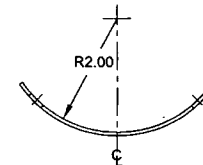
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

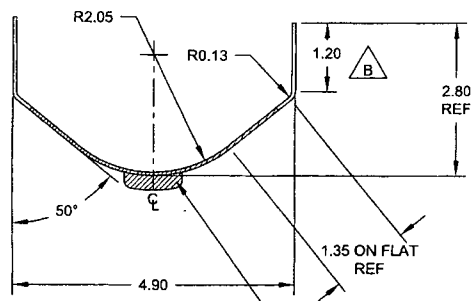
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

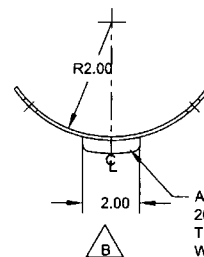


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

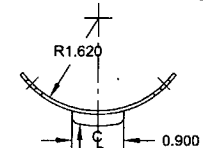


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

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2011-10-31
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| CHECKED | AP | DRAWING NO. | REV. B |
| MFG. APPR. | AP | D4095 | SHEET 8 OF 8 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | WEARPLATE | NTS |
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